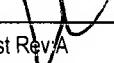


Shop ~~08/10~~Date: Friday, 03/10/2008 9:02:59 AM
User: Linda Lacelle

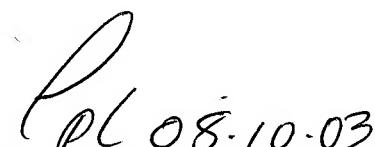
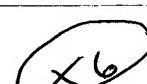
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: "T" HANDLE ASSEMBLY	
Job Number	: 42434				Part Number	: D2282041	
Estimate Number	: 11179				Drawing Number	: D2282 REV E	
P.O. Number	:				Project Number	: N/A	
This Issue	: 03/10/2008 S.O. No. :				Drawing Revision	: E	
Prsht Rev.	: NC				Material	:	
First Issue	: / / Type : LARGE FAB ASSY				Due Date	: 10/10/2008	
Previous Run	: 41767A					Qty:	6 Um: Each
Written By	: 						
Checked & Approved By	: 						
Comment	: Est Rev A Removed from 9 Digit 05-12-02 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D22823	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-3	Handle tube <u>B38640</u> → 5 <u>B41889</u> → 1 ✓	
2.0	D22825	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-5	Handle tube <u>B39717</u> ✓	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Weld as per D2282-041 'T' Handle Assembly	
		Grind chamfers and ensure full penetration as per dwg D2282	
		*****brush weld right after welding, to take color off*****	
	A/R ER316L SS	Filling Rod <u>M10174</u>	
		Dwg Rev: <u>E</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 03/10/2008 9:02:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 42434

Part Number: D2282041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 0810-06 (6)

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

HB 8-10-9

Tumble

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/07 (6)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P. 1/10-9 (6)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/07 (6)

Job Completion



mf 08-10-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

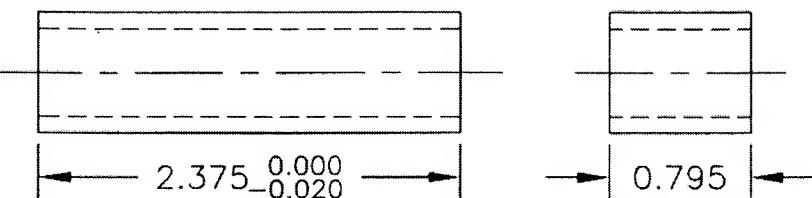
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>FZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

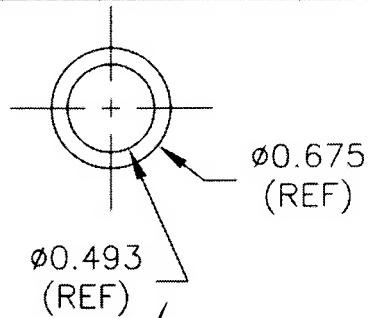
RELEASED
05/09/16



D2282-3

D

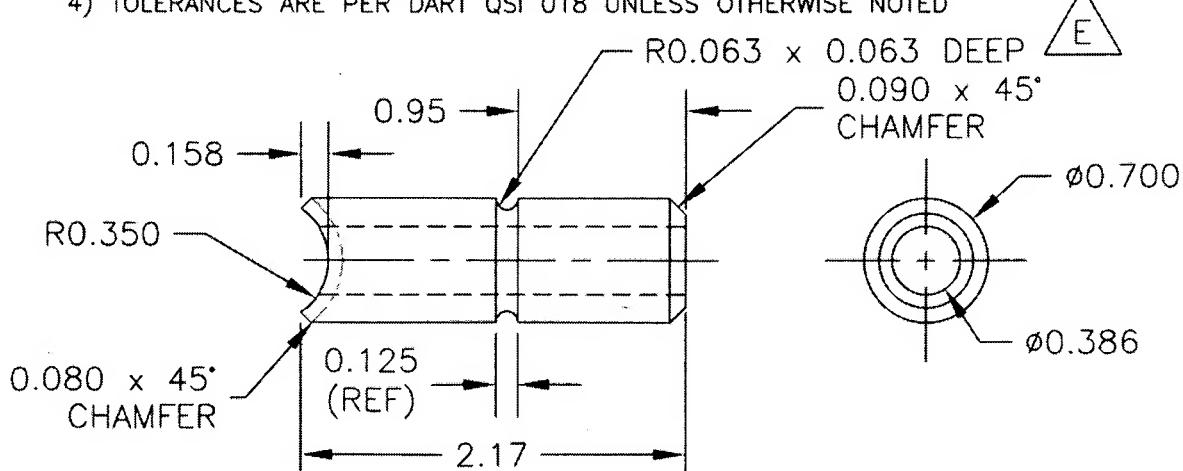
D2282-7



w/o 42434

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D

D2282-5

E

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

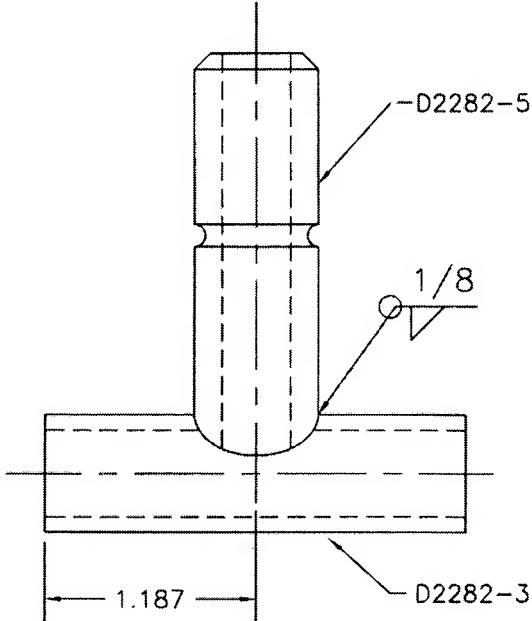
E

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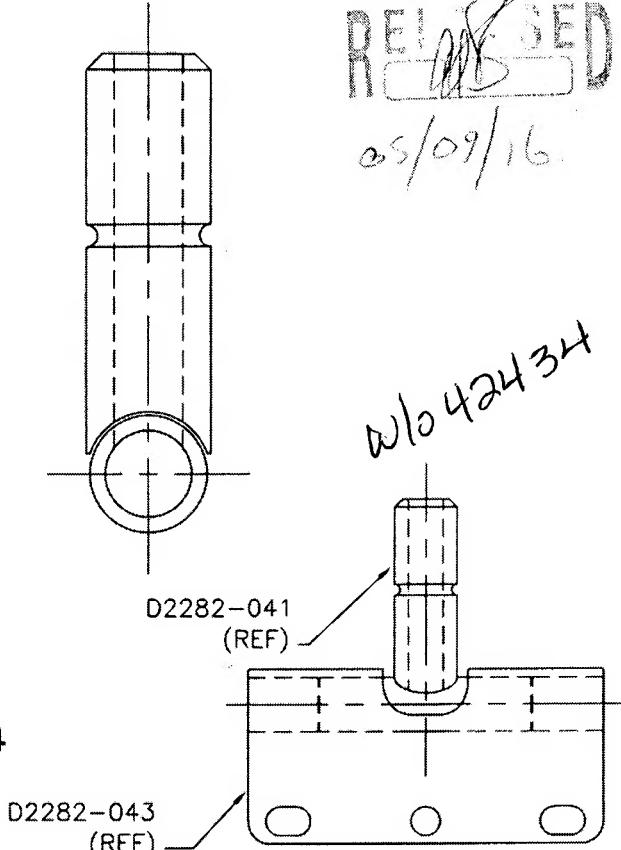
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DART

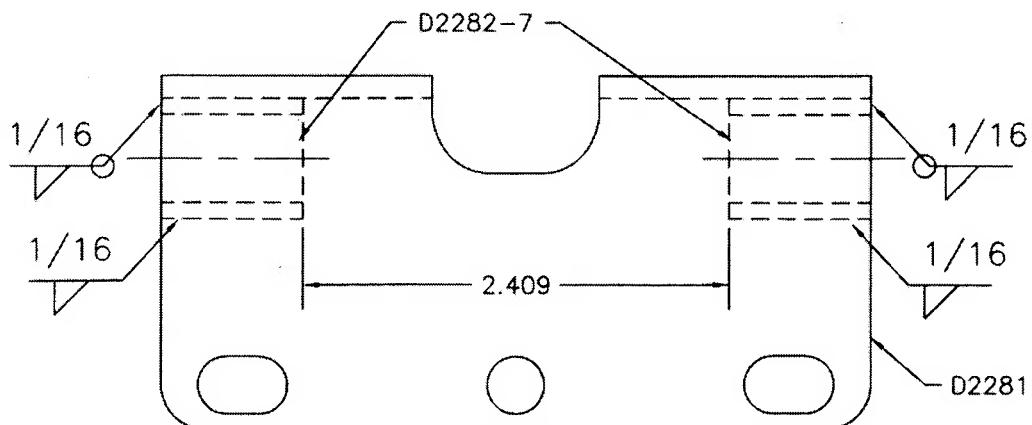
DESIGN BW	DRAWN BY <i>FB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>MLB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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